

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

**RELEASED**  
05-06-16 [Signature]

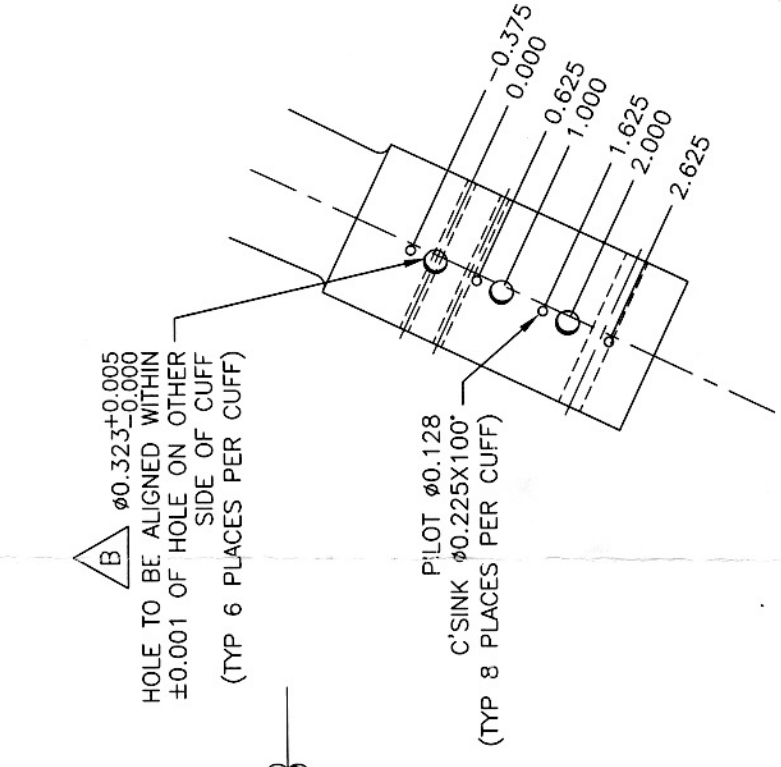
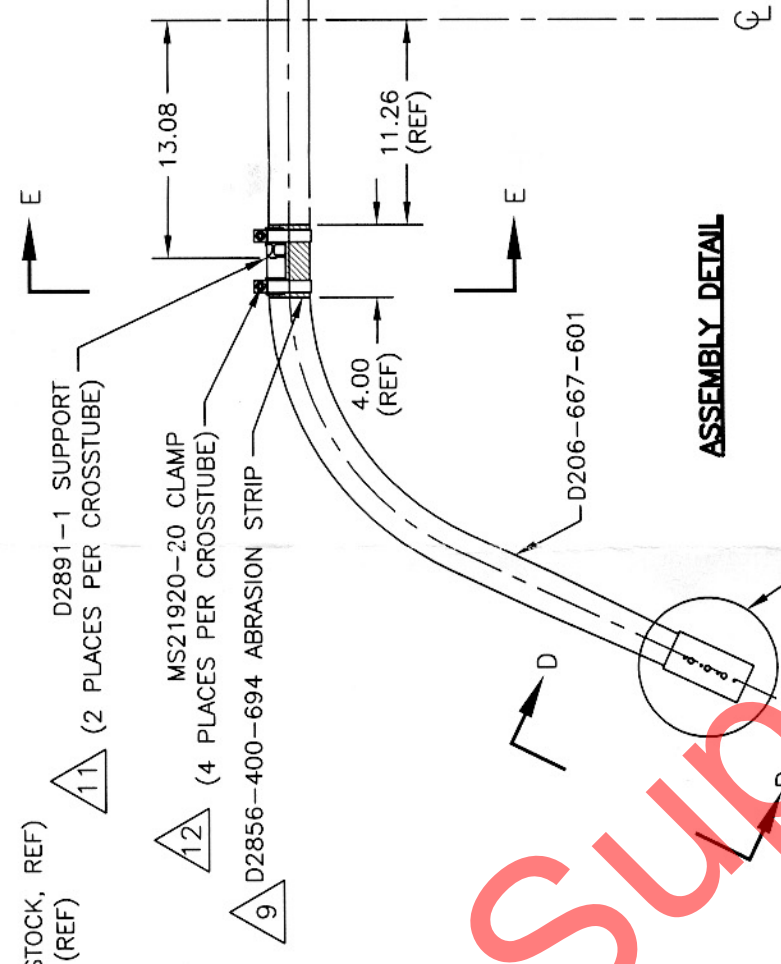
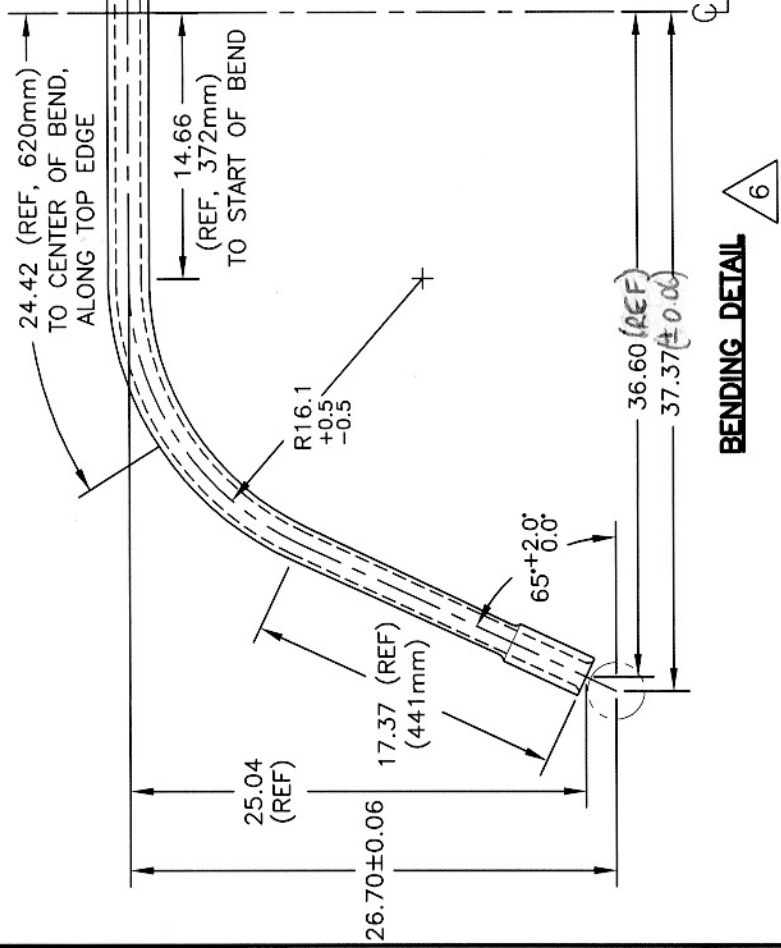
Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

**GENERAL NOTES:**

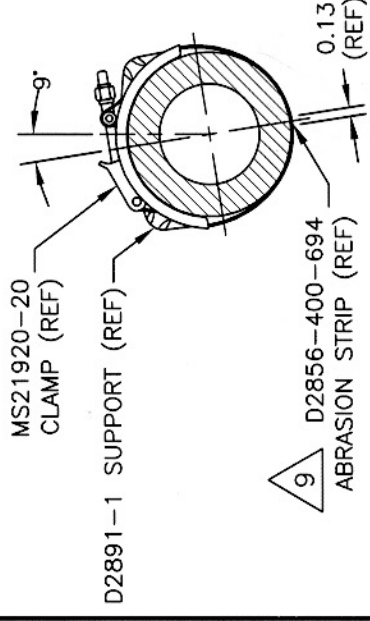
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102  
FINISHED LENGTH =  $100.60 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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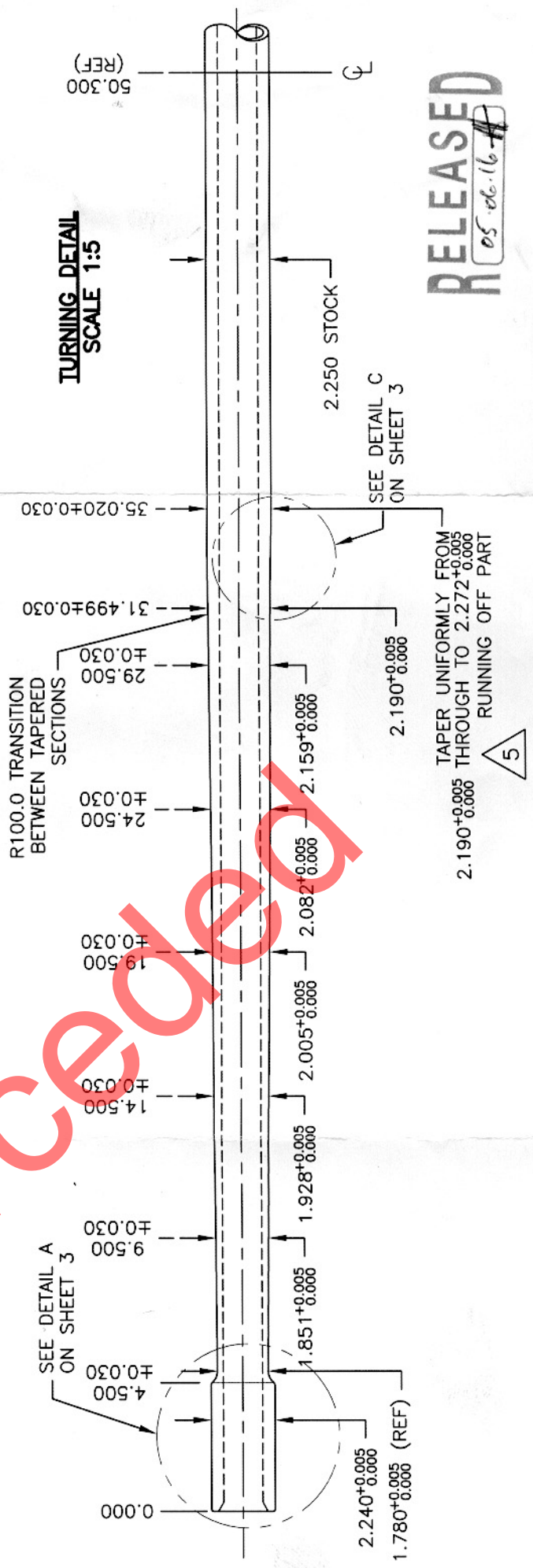
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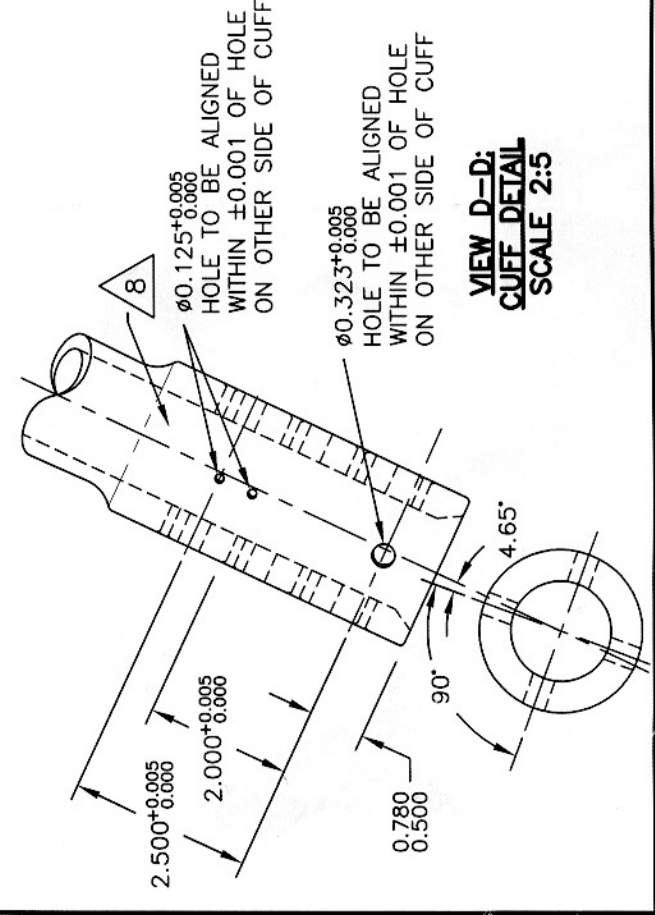
DETAIL F  
SCALE 2:5



SECTION E-E  
SCALE 2:5



TURNING DETAIL  
SCALE 1:5



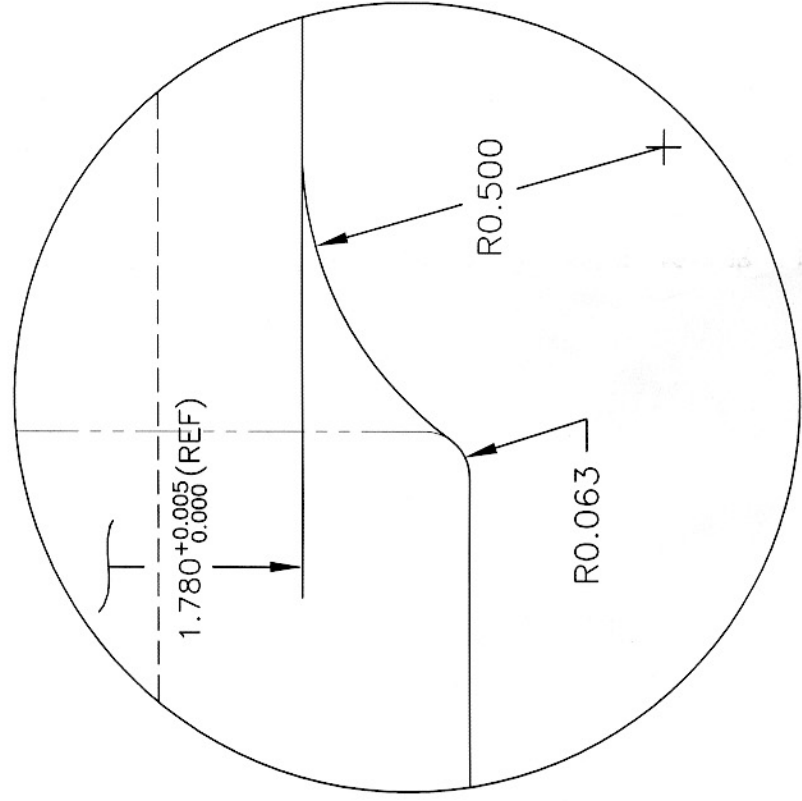
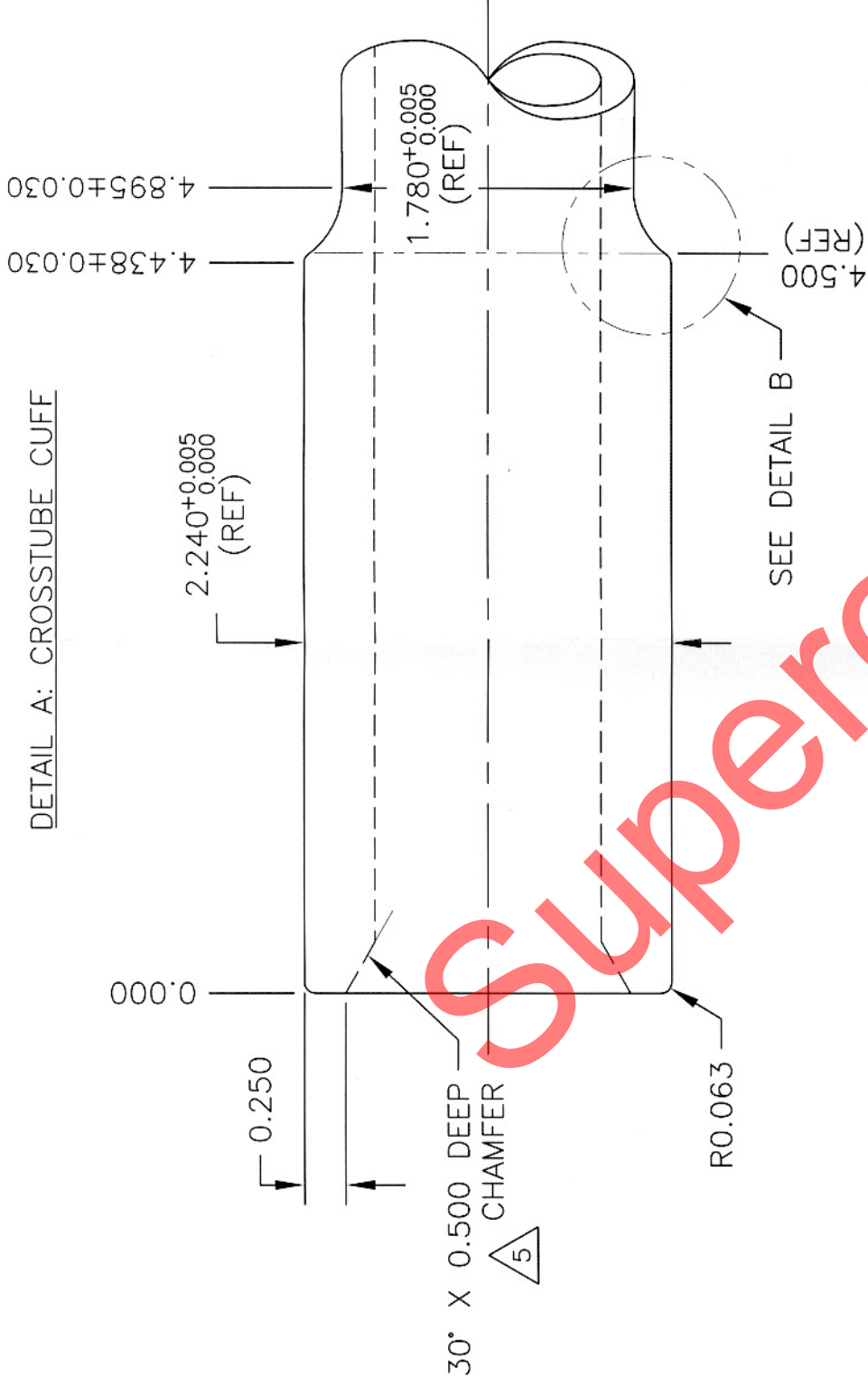
VIEW D-D:  
CUFF DETAIL  
SCALE 2:5

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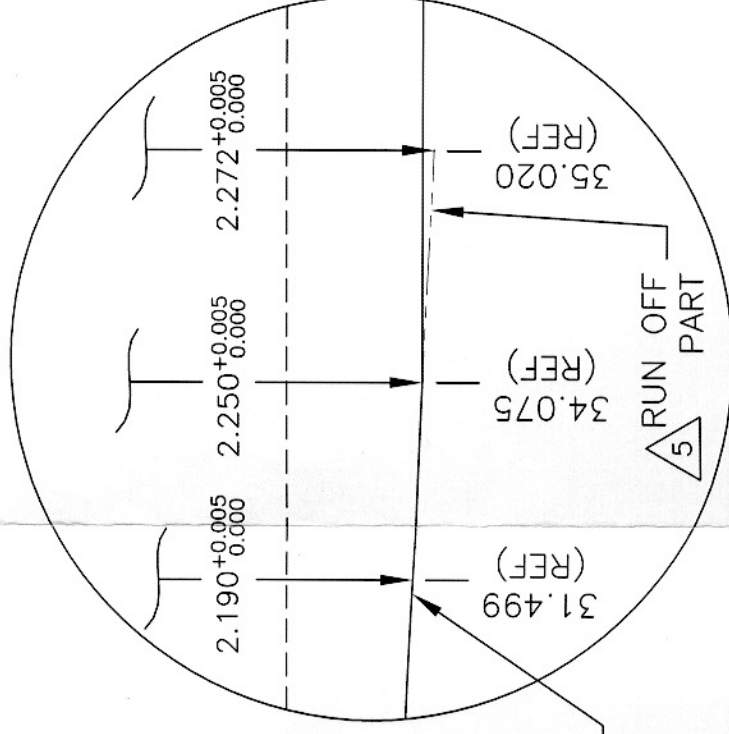
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		DATE		D206-667-241	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206B HIGH AFT)	1:10



DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE

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05-06-16

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DATE		05.02.04		DRAWING NO.		D206-667-241	
				REV. B		SHEET 3 OF 3	
				TITLE		CROSSTUBE ASS'Y (206B HIGH AFT)	
				SCALE		1:1	